

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027866**Date Inspected:** 26-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Andrew Keech**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI was tasked with continuing to scan Electro Slag Weld (ESW) weld V. The QAI noted that repairs are in progress in the 1 meter area and conducted UT on accessible portions of the weld above the area being repaired. The QAI noted that during the Ultrasonic Testing (UT) examination, multiple indications were observed. The QAI noted that these indications are located while performing scanning pattern E and generally appear to have a transverse planar orientation. The QAI noted that the weld cap is not ground flush. The UT inspection was performed using 70 degree shear wave from face B. The indications did not have a rating that qualifies as rejectable or recordable according to AWS D1.5 2002. The QAI noted that the inspected area contains rejectable indications that have been identified by the Quality Control (QC) inspections previously performed and the repairs are pending at this time. The inspection of this weld was stopped due to interference caused by the induction heaters. The QAI moved to ESW weld R face A at the 9 meter diaphragm and continued the UT examination. This work was in progress at the end of this shift. The findings are listed below.

Y location: dB rating: Sound Path: notes:

3005 19 127

3075 15.9 153.67

3115 9.56 119.89 up/down

3230 18.86 103.38 up/down

3350 10.3 123.19 up/down

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## WELDING INSPECTION REPORT

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3360 12.02 101.35 cluster  
3430 15.06 88.14 wide  
3450 13.04 126.49  
3505 15.28 98.04  
3600 7.46 95.76  
3625 12.5 107.95 wide  
3700 8.4 109.22  
3875 10.66 107.19  
3880 11.52 133.1  
3910 9.96 127.51  
4060 13.64 131.57 grouped  
4155 11.54 120.14 grouped  
4170 14.6 93.98 grouped  
4190 17.94 115.06 wide  
4360 12.26 110.1  
4460 14.54 116.33  
5055 5.98 139.95  
5085 6.46 159.26 up/down  
5100 17.52 107.7  
5360 7.84 116.33 up/down

### Summary of Conversations:

The QAI relayed the status of the UT inspections to the QAI Lead Bill Levell and Danny Reyes. There were other conversations between the QAI and ABF personnel regarding the access to welds and repairs in progress. The QAI did not monitor any welding or repairs during this shift. Except as described above, there were no other notable conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Croff, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

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